

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BAFFLE	
<b>Job Number</b>	: 32061			
<b>Estimate Number</b>	: 12216			
<b>P.O. Number</b>	:	<b>Part Number</b>	: D346713	
<b>This Issue</b>	: 4/25/2007      S.O. No. :	<b>Drawing Number</b>	: D3467 REV.B	
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A	
<b>First Issue</b>	: / /      Type : SMALL /MED FAB	<b>Drawing Revision</b>	: B	
<b>Previous Run</b>	: 28591	<b>Material</b>	:	
<b>Written By</b>	: _____	<b>Due Date</b>	: 5/8/2007	<b>Qty:</b> 2   Um:       Each
<b>Checked &amp; Approved By</b>	: _____			
<b>Comment</b>	: est rev. A 06-04-20    new issue   EC Est Rev:B   As per Rev B 06-05-24 JLM			

Job Number:

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 M304S26GA 304/316 0.018 SHEET

Comment: Qty.: 0.1575 sf(s)/Unit Total: 0.3150 sf(s)  
304/316 0.018 SHEET batch: ml0367

2.0 WATER JET  FLOW WATER JET

Comment: FLOW WATER JET

Cut as per Dwg D3467.

Dwg Rev: \_\_\_\_\_

Prog Rev:

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0                      QC8                      SECOND CHECK

**Comment:** SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

### 1-Deburr

2-Bend as per dwg D3467

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/02/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:37:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE

Job Number: 32061

Part Number: D346713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*2008/2/25 (2)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *96*

*8/2/25*

*50 (ex)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(2)*

*2008/2/26*

Job Completion



*2008/2/25*

*(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32061
<b>Description:</b> Baffle		<b>Part Number:</b>	D3467-13
<b>Inspection Dwg:</b> D3467 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

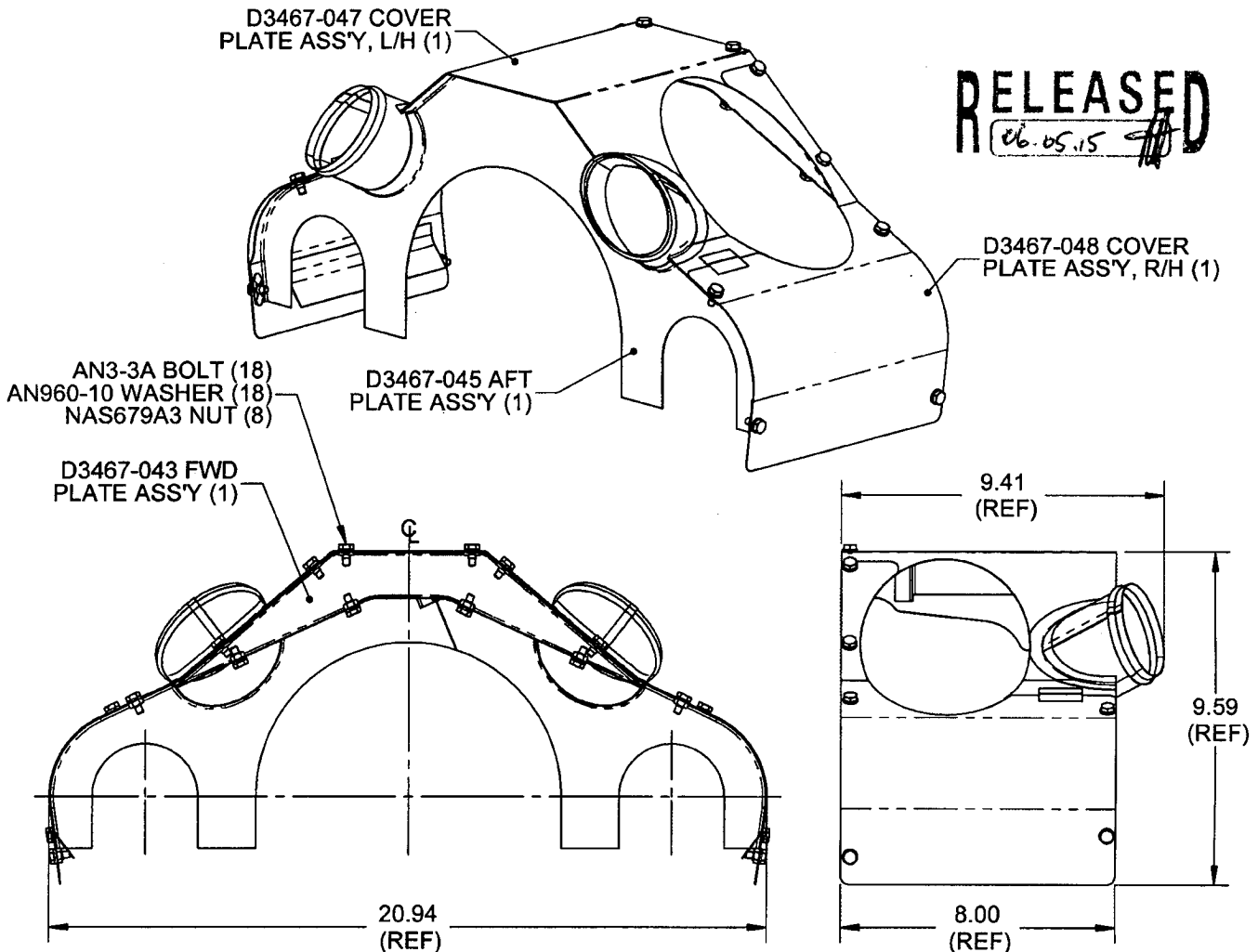
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2.000	+/-0.010	2.000	✓		vern	
1.370	+/-0.010	1.369	✓		vern	
1.370	+/-0.010	1.368	✓		vern	
3.38	+/-0.030	3.38	✓		vern	
2.125	+/-0.010	2.126	✓		vern	
Ø0.750	+0.008/-0.001	0.752	✓		vern	
0.018	+/-0.010	0.018	✓		vern	

<b>Measured by:</b>	m. nm	<b>Audited by:</b>	MA	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/04/26	<b>Date:</b>	07/05/08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	BE

**DART**

DESIGN <i>JB</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>ME</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 1 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:5
A	05.12.07	NEW ISSUE	
B	06.05.15	Ø0.250 & Ø0.203 WERE Ø0.194 ; UPDATED D3467-9F/-15F	

**D3467-041 SHROUD ASSEMBLY****NOTES:**

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3467-041	SHROUD ASSEMBLY
1	D3467-043	FWD PLATE ASSEMBLY
1	D3467-045	AFT PLATE ASSEMBLY
1	D3467-047	COVER PLATE ASSEMBLY, L/H
1	D3467-048	COVER PLATE ASSEMBLY, R/H
18	AN3-3A	BOLT
18	AN960-10	WASHER
8	NAS679A3	NUT

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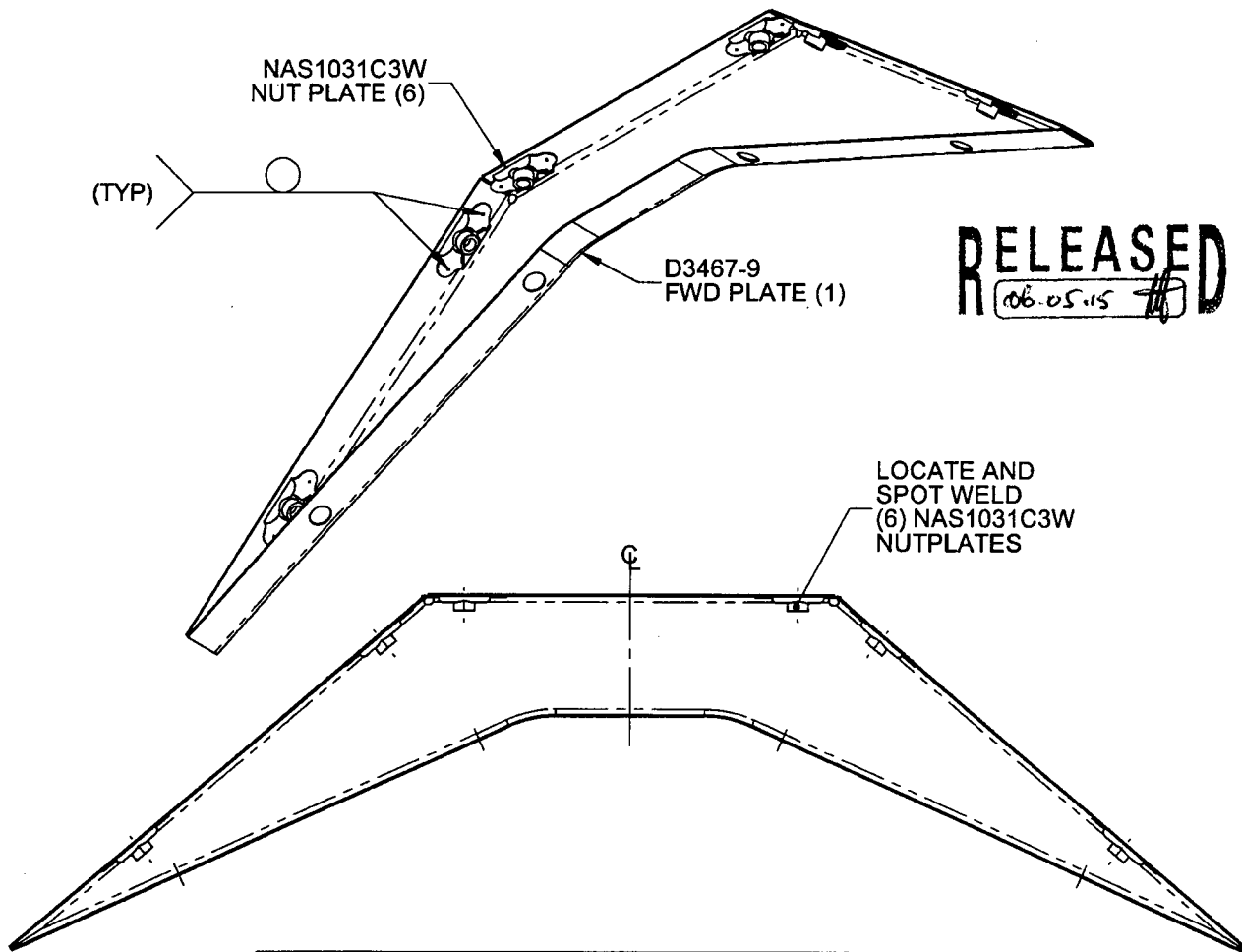
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CHECKED 13	APPROVED 13	DRAWING NO. D3467	REV. B SHEET 2 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2



QTY -043	P/N	DESCRIPTION
X	D3467-043	FWD PLATE ASSEMBLY
1	D3467-9	FWD PLATE
6	NAS1031C3W	NUT PLATE

### D3467-043 FWD PLATE ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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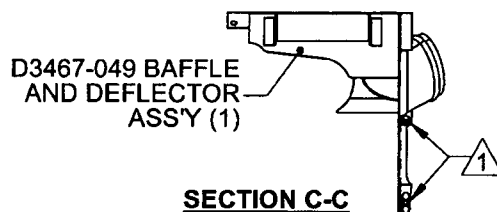
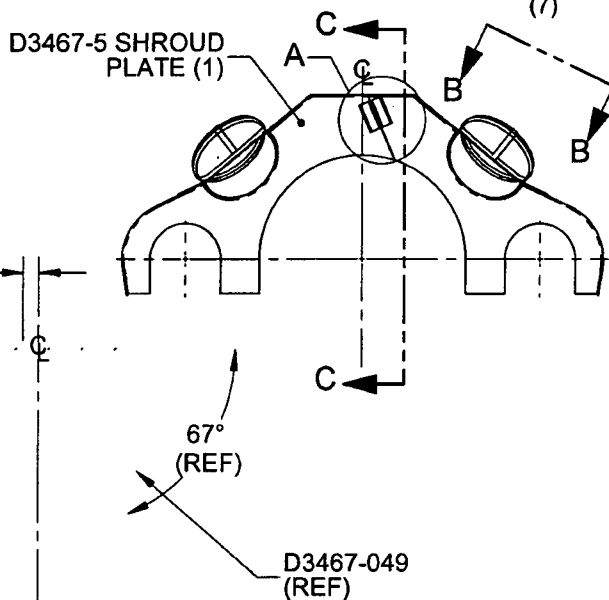
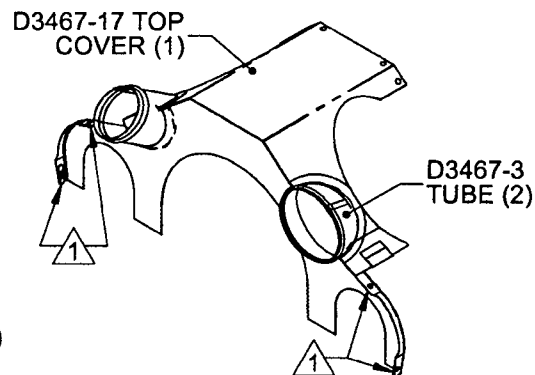
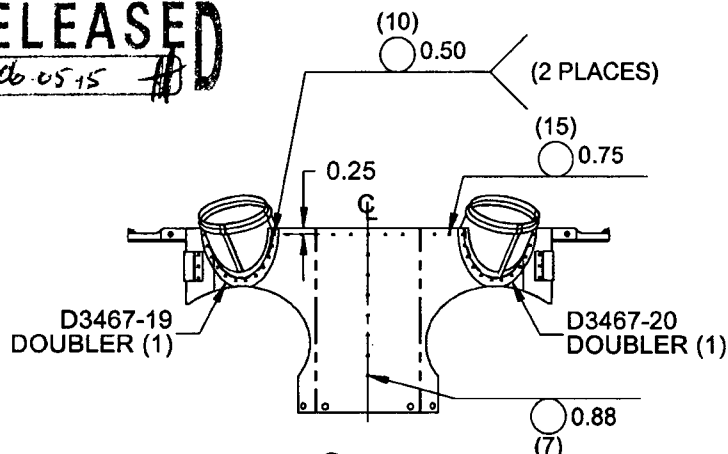
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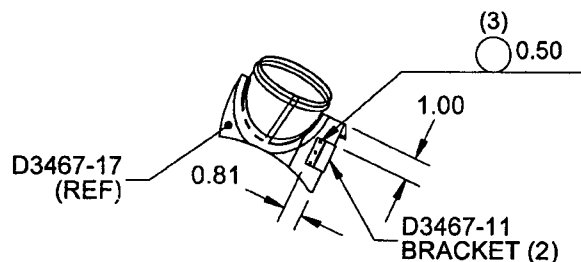


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 3 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8

**RELEASED**  
06-05-15



**SECTION C-C**



**VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)

**DETAIL A**  
SCALE 1:2

**D3467-045 AFT PLATE ASSEMBLY**

**NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

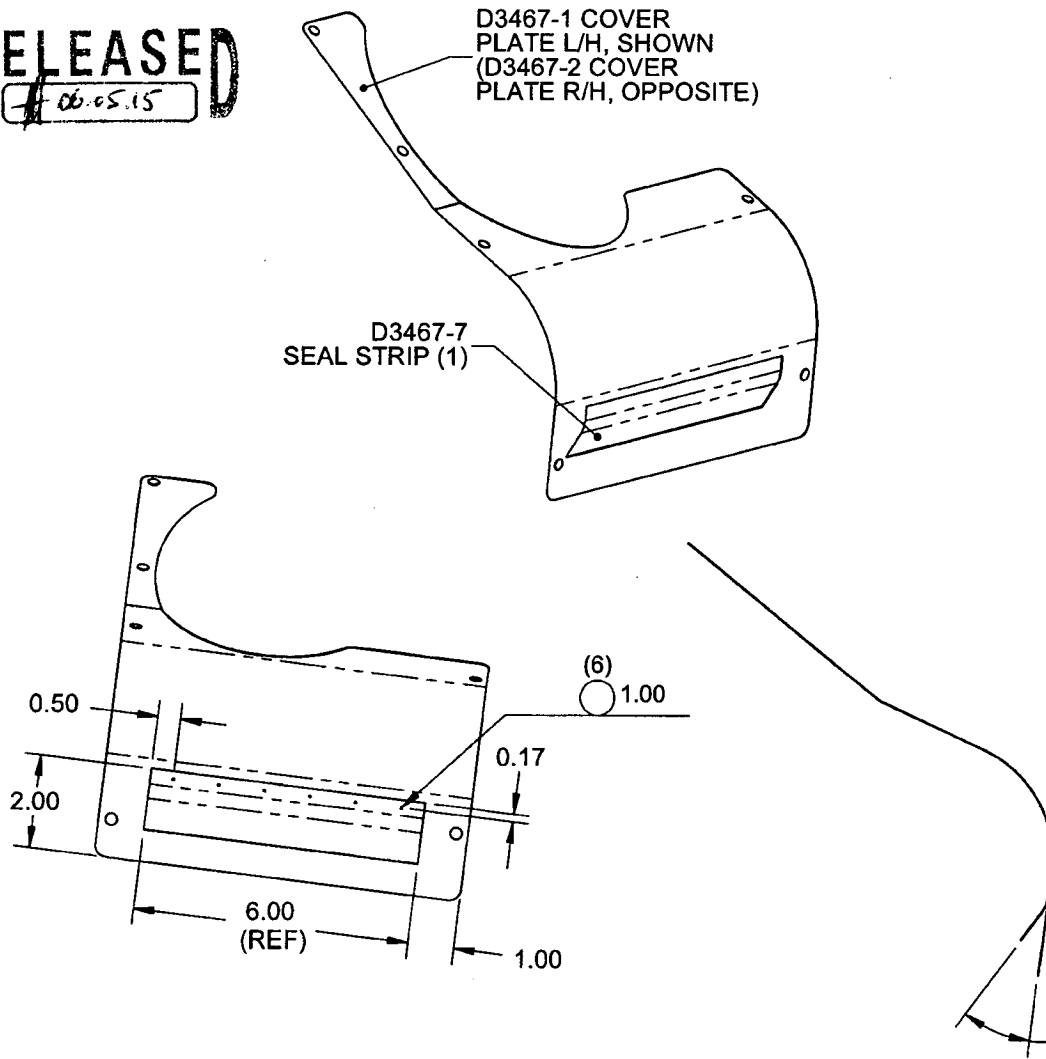
QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:4

**RELEASED**  
06.05.15

**D3467-047 COVER PLATE ASS'Y L/H, SHOWN**  
**D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO  
0.010

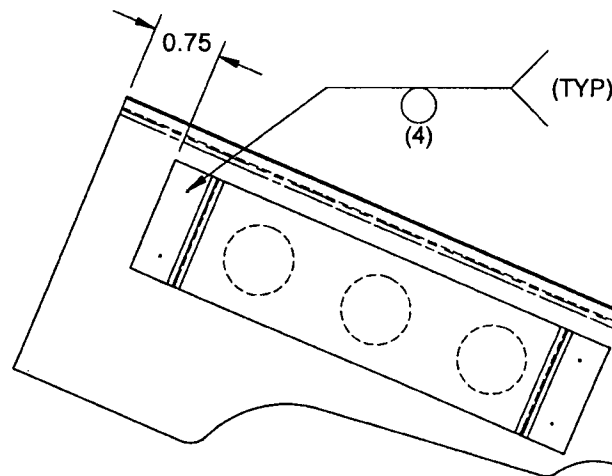
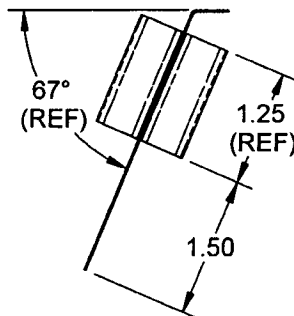
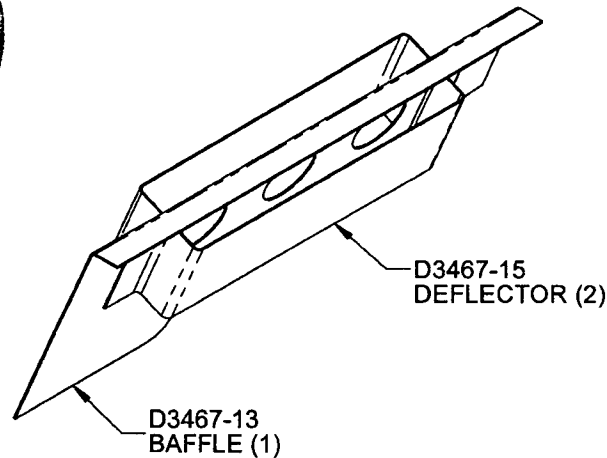
QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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CHECKED #1	APPROVED #1	DRAWING NO. <b>D3467</b>	REV. B SHEET 5 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
#1 06.05.15**D3467-049 BAFFLE & DEFLECTOR ASSEMBLY**

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**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

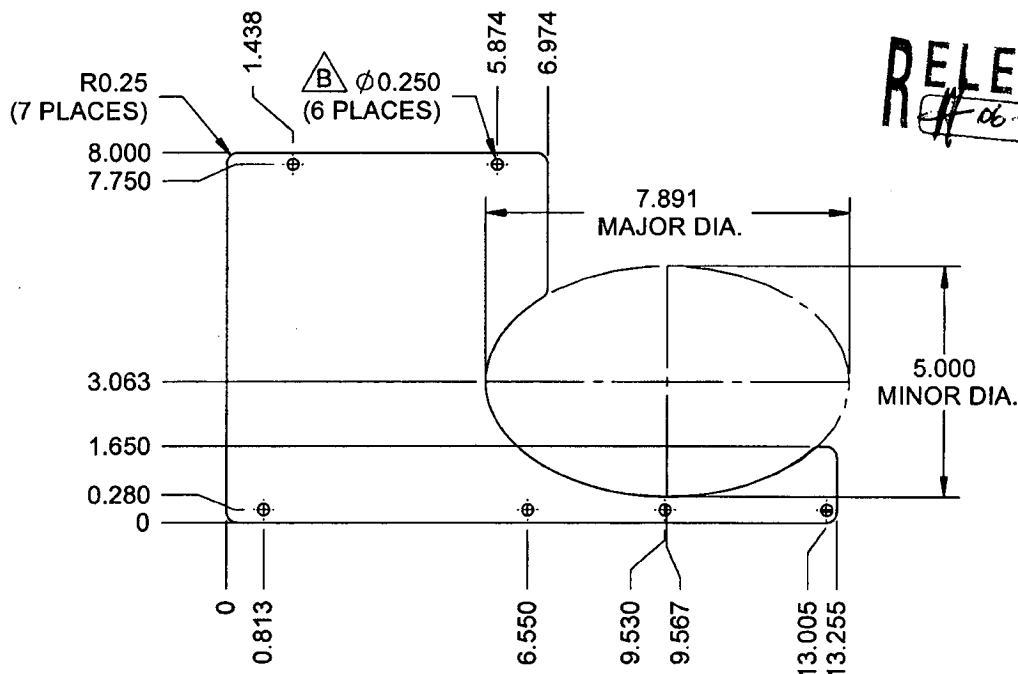
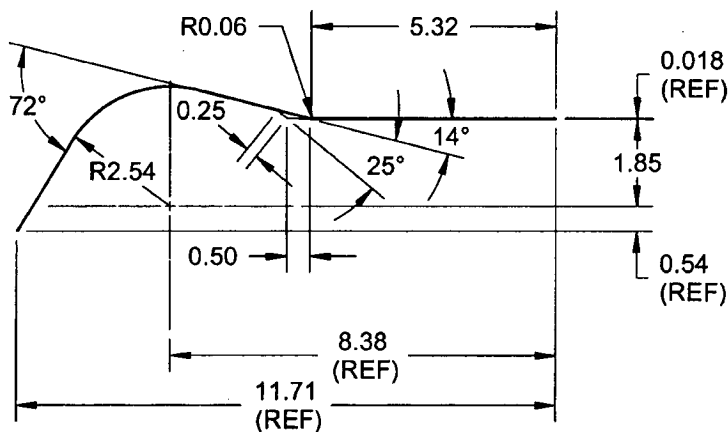
QTY -049	P/N	DESCRIPTION
	<b>D3467-049</b>	<b>BAFFLE &amp; DEFLECTOR ASSEMBLY</b>
1	D3467-13	BAFFLE
2	D3467-15	DEFLECTOR

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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER PLATE  
D3467-2 R/H COVER PLATE (OPPOSITE)****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3467-1 L/H COVER PLATE ISOMETRIC VIEW.  
D3467-2 R/H COVER PLATE (OPPOSITE)**

SCALE 1:8

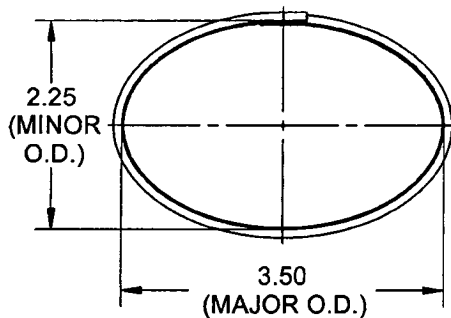
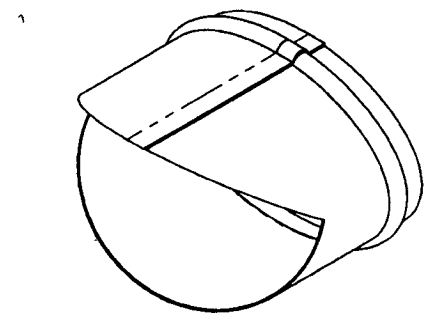
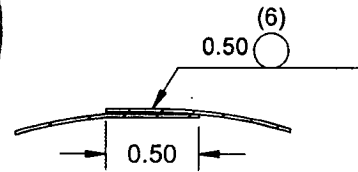
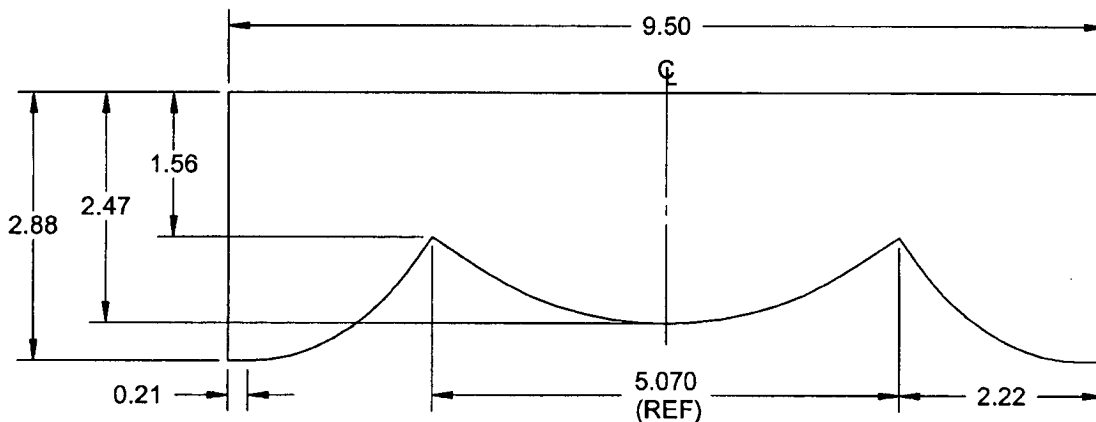
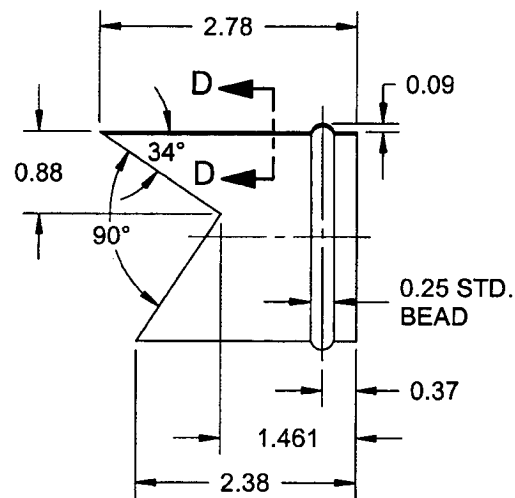
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 7 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
*06.05.15***D3467-3 TUBE DETAIL****SECTION D-D**  
SCALE 1:1**D3467-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

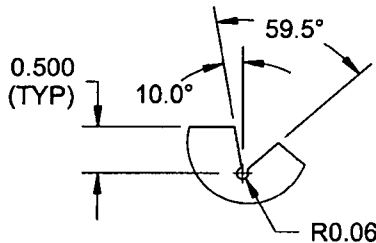
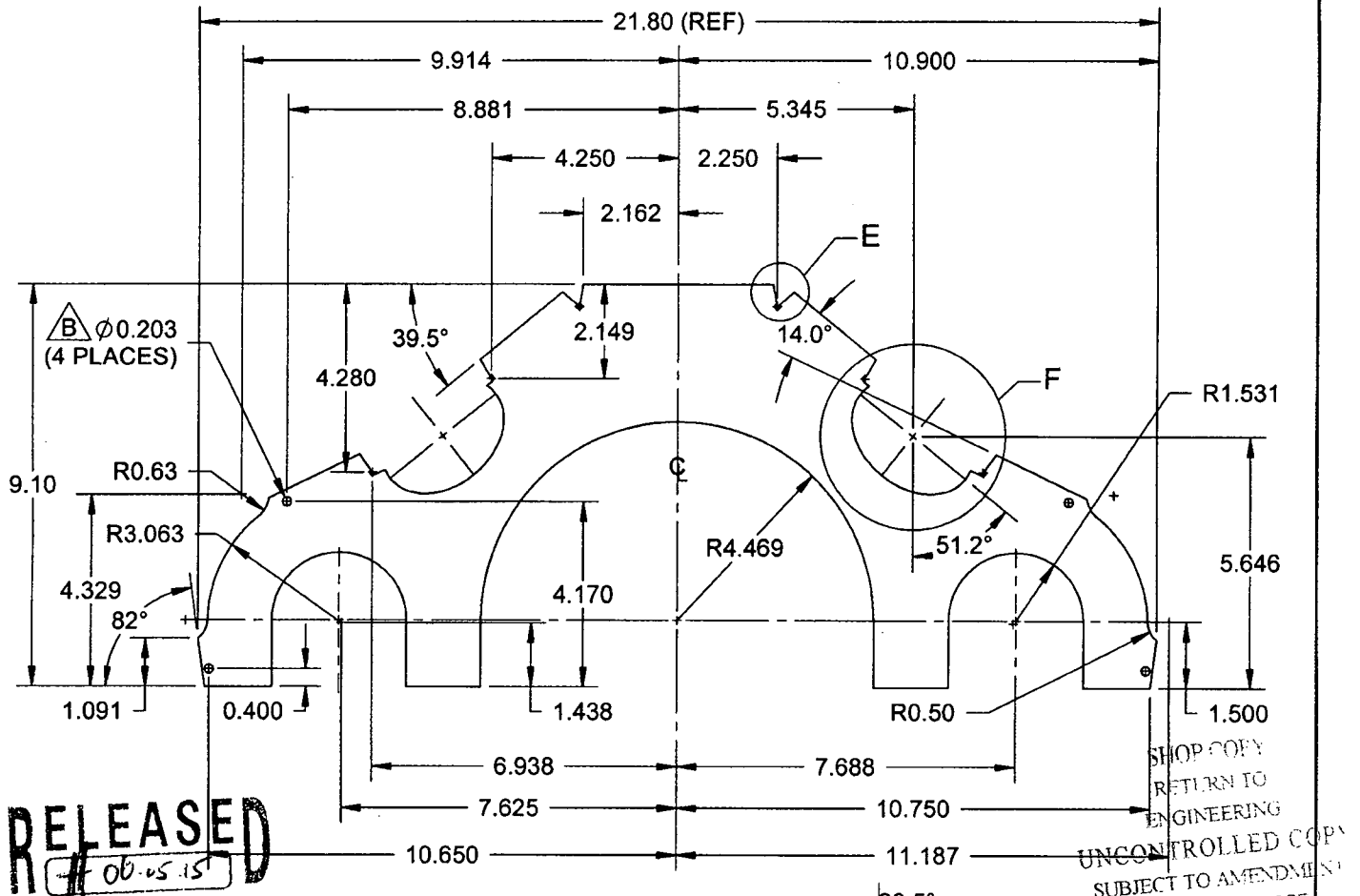
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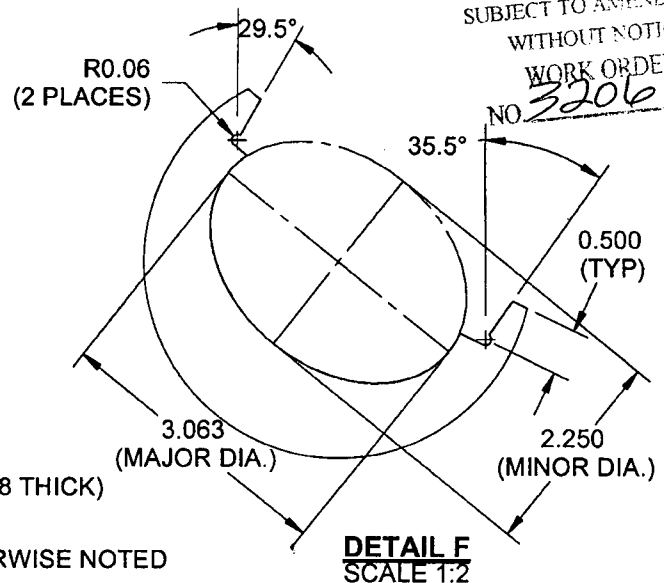
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CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 8 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8



**DETAIL E**  
SCALE 1:2



**DETAIL F**  
SCALE 1:2

### **D3467-5F AFT PLATE FLAT PATTERN**

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

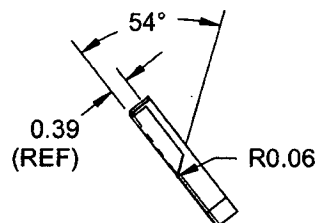
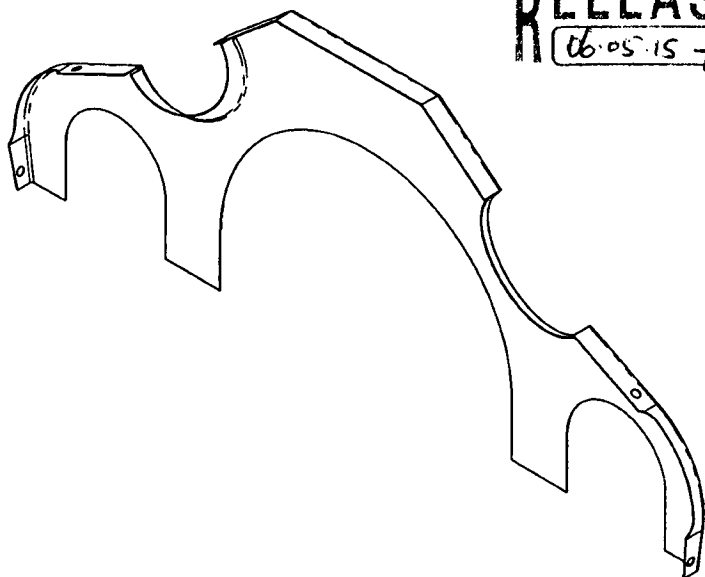
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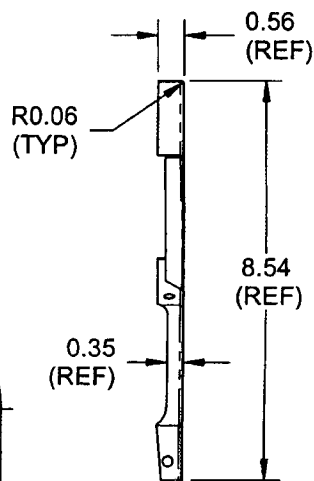
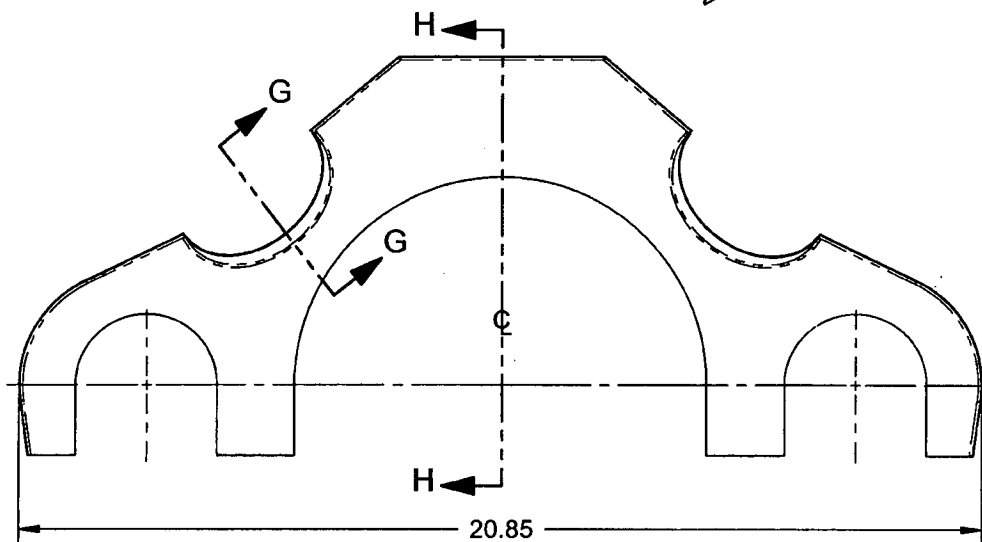


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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4

**RELEASED**  
*[Stamp: 06.05.15]*



**SECTION G-G**



**SECTION H-H**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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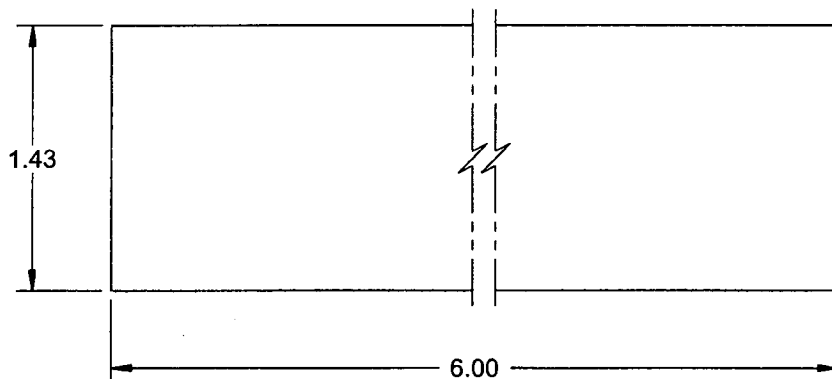
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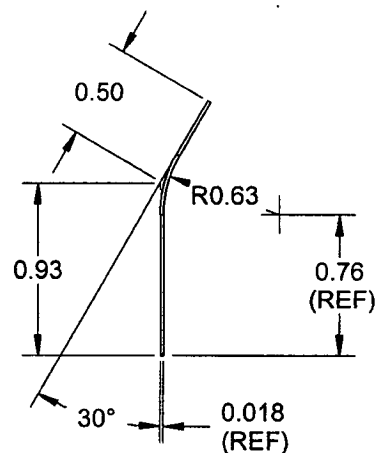


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. B SHEET 10 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:1

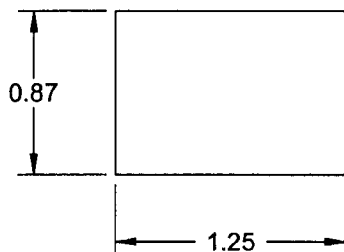
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06.05.15 *[Signature]*



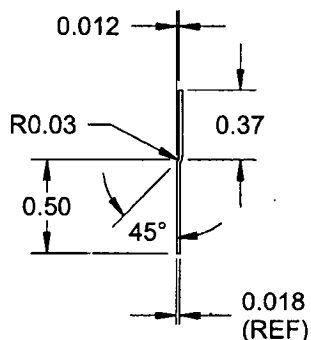
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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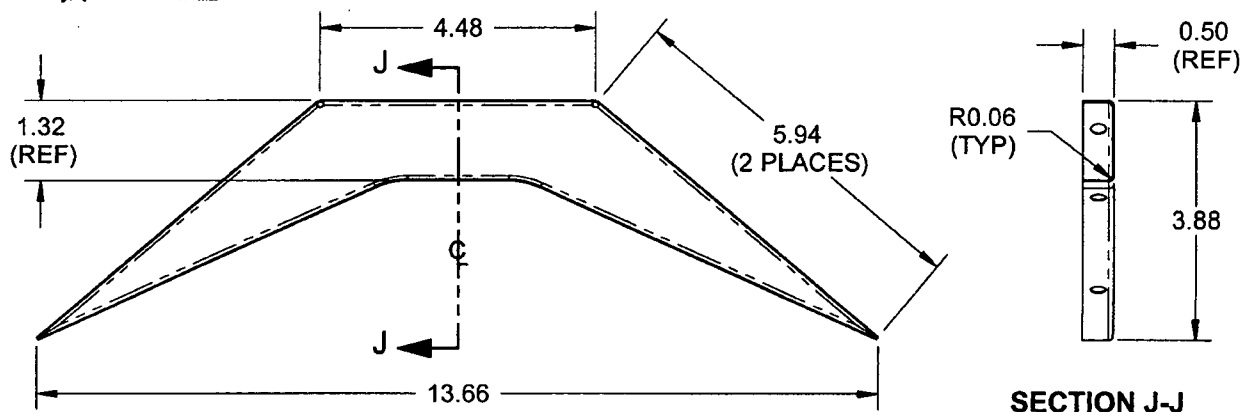
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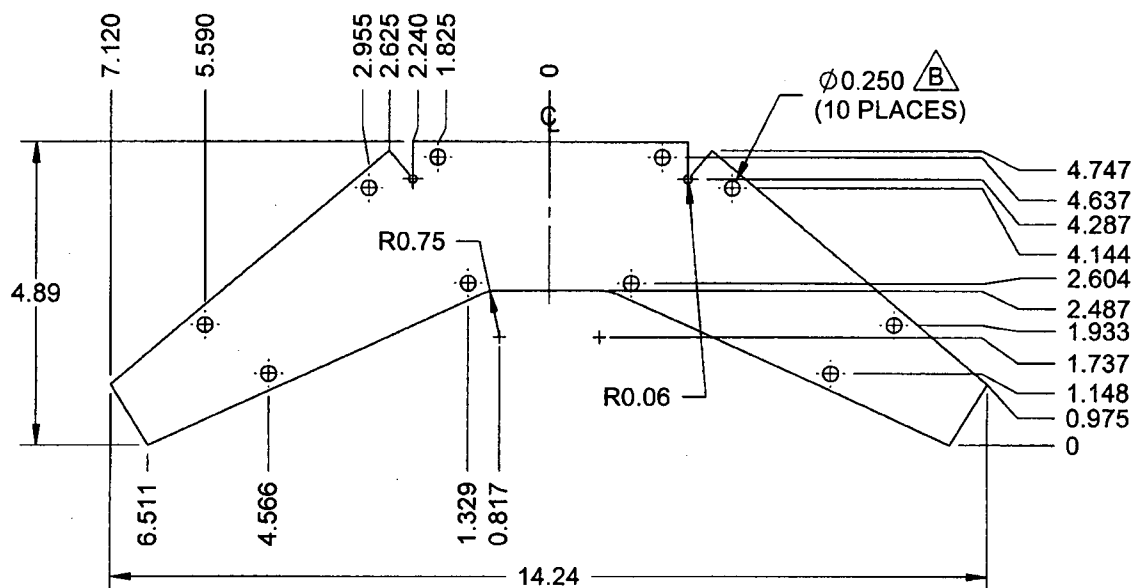


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CHECKED H	APPROVED H	DRAWING NO. <b>D3467</b>	REV. B
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SHEET 11 OF 15 SCALE 1:3

**RELEASED**  
06.05.15



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

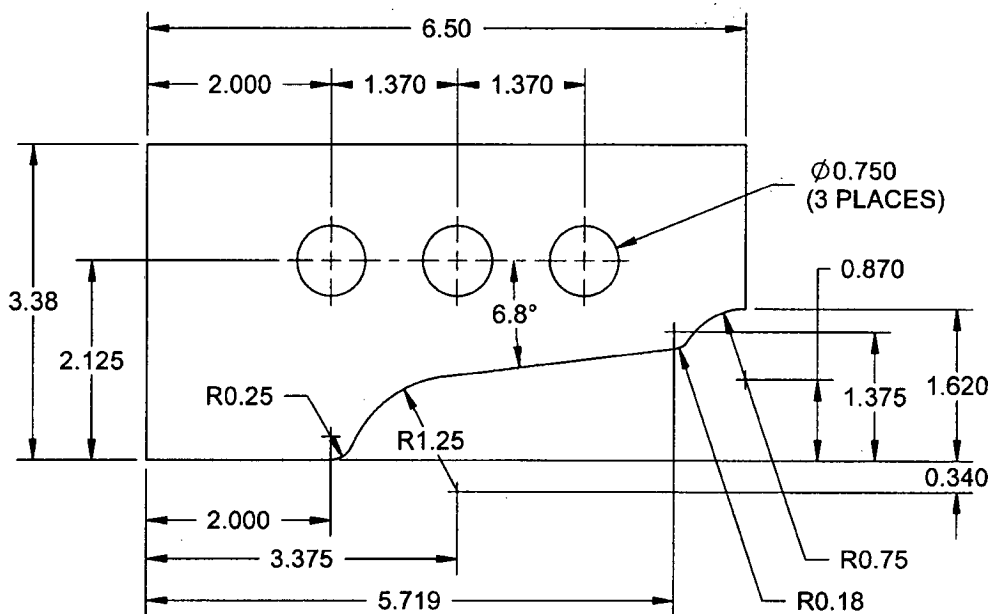
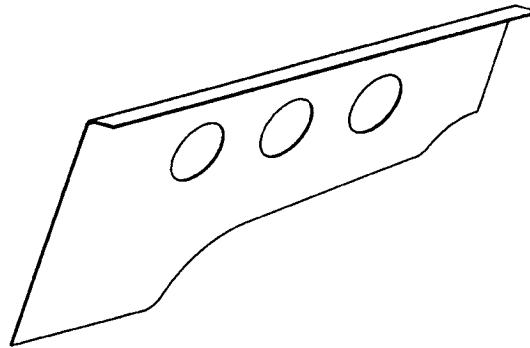
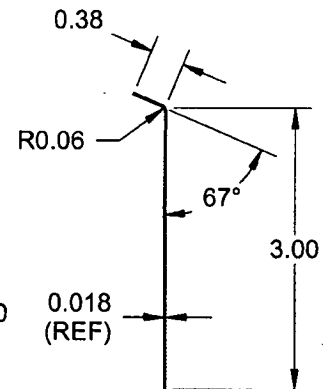
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3467</b>	REV. B SHEET 12 OF 15
DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
*# 06.05.15***D3467-13F BAFFLE  
FLAT PATTERN****D3467-13 BAFFLE  
BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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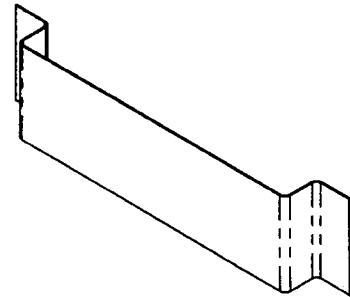
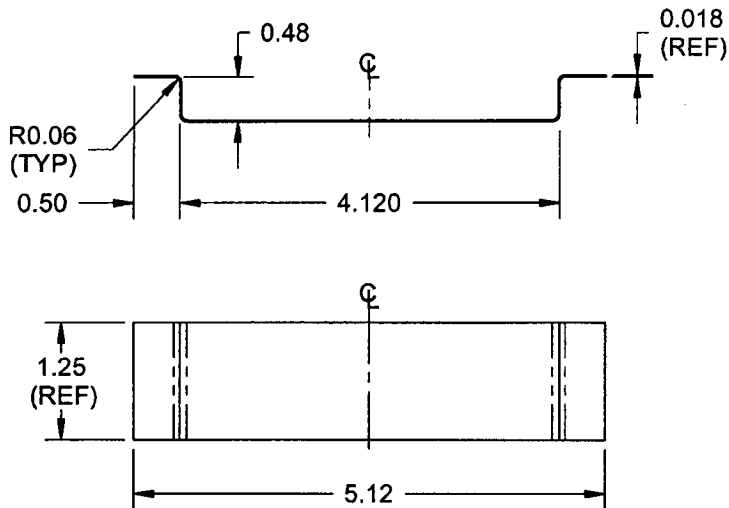
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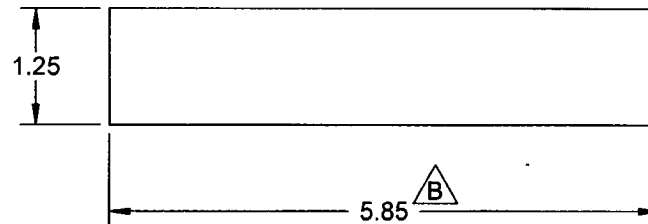


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DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

RELEASED  
06.05.15



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

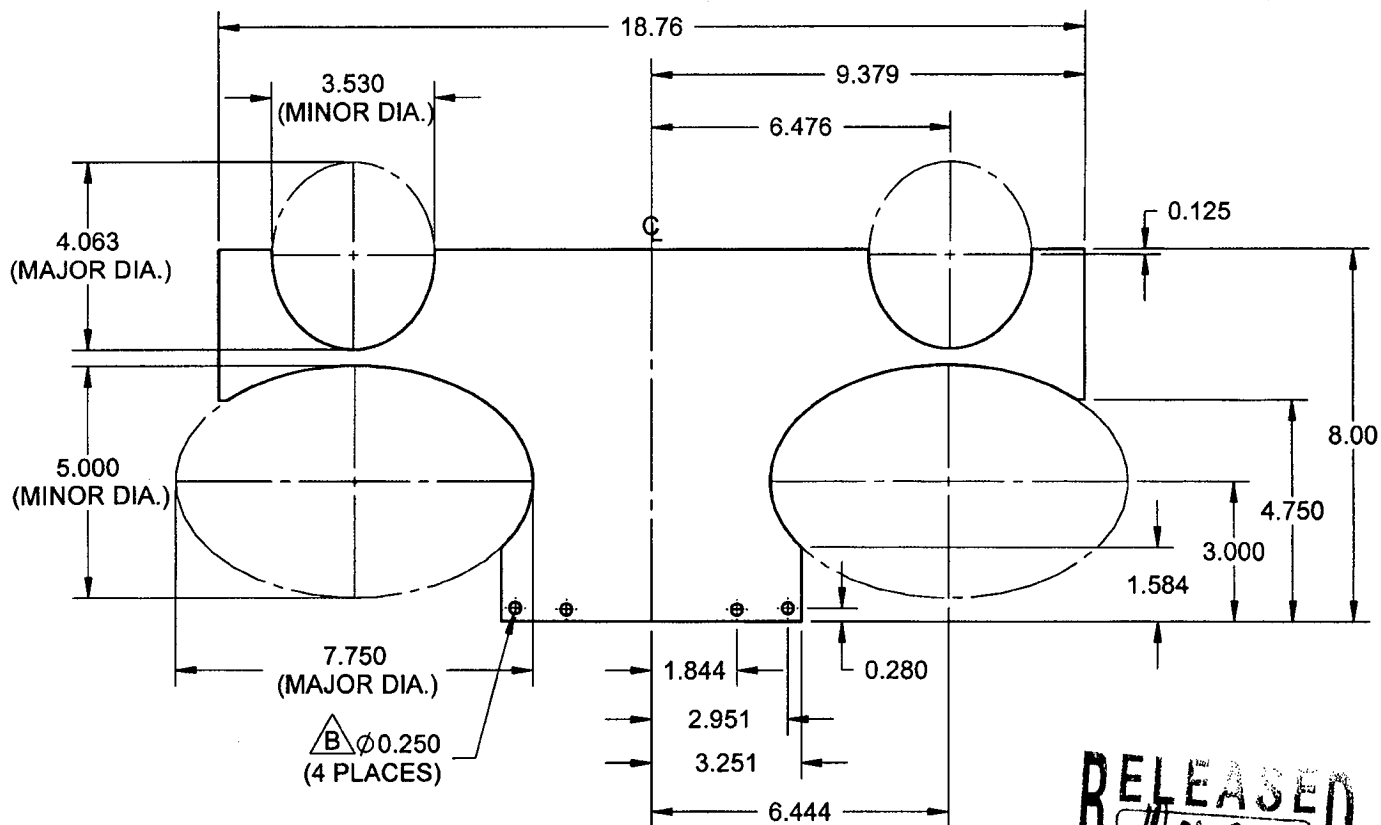
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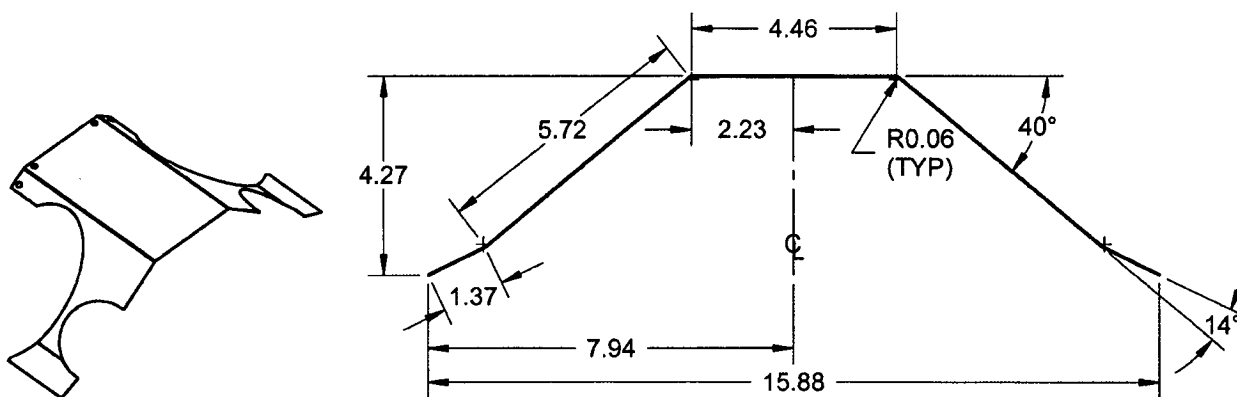


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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4



**D3467-17F TOP COVER FLAT PATTERN**

RELEASED  
#06-05-15



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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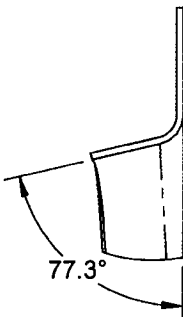
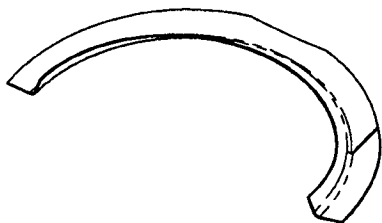
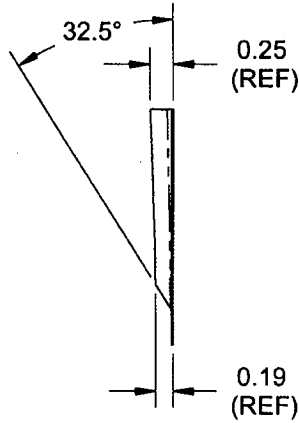
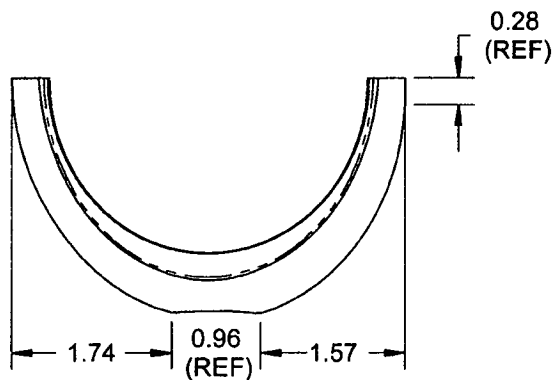
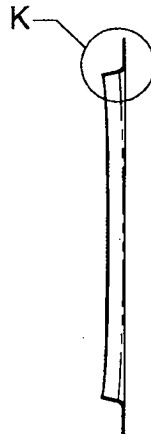
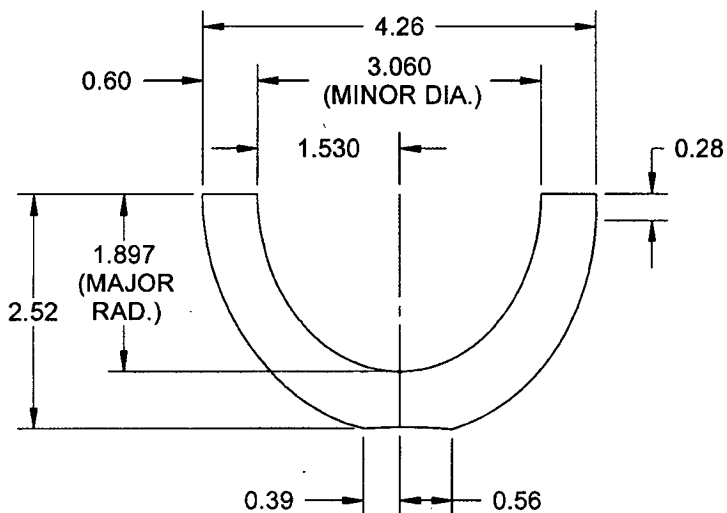
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DATE <b>06.05.15</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2

**RELEASED**  
*06.05.15***DETAIL K**  
SCALE 1:2**D3467-19 DOUBLER, L/H SHOWN**  
**D3467-20 DOUBLER, R/H OPPOSITE**

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**D3467-19F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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